

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010875**Date Inspected:** 18-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During the Quality Assurance random in-process visual inspection of Segment 7CW, this Quality Assurance Inspector (QA) discovered the following issue:

-Base metal repairs being performed in way of temporary attachment removal areas on the bottom and side plates without the prior approval of the engineer.

The plate identifications under repair are identified as:

- SP126A, Plate number-PL250A
- SP153A, Plate Number-PL533A
- SP719A, Plate Number-PL622A
- SP481A, Plate Number-PL621A
- SP440A, Plate Number-PL1279A
- BP91A, Plate Number-PL735A
- BP37A, Plate Number-PL708A
- BP145A, Plate Number-PL789A
- The material is A709 Grade 345 non SPCM:

OBG Segment 7CW is located in the segment repair yard north of the blast shop.

For further information, please see the attached pictures. Please see incident report on this date.

This QA inspector received NDT Inspection notification sheet #004866, dated 12.15.09, for QA verification

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Ultrasonic Testing (UT) of OBG Segment 7CW. This NDT notification document represents ZPMC's submittal for formal acceptance of (UT) for all Complete Joint Penetration (CJP) welds in this segment. Upon arrival to the segment it was observed that ZPMC was in the process of Visual inspection with multiple areas on the side plate splice joint in repair leaving the re-inspection of these required NDT incomplete. The weld designation affected is SEG37A-001.

For further information, please see the attached pictures. Please see incident report on this date.

Segment 8BW

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(CA49A-003, 004)

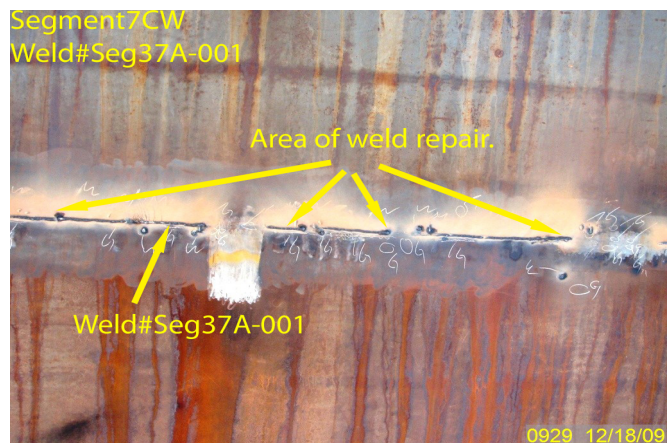
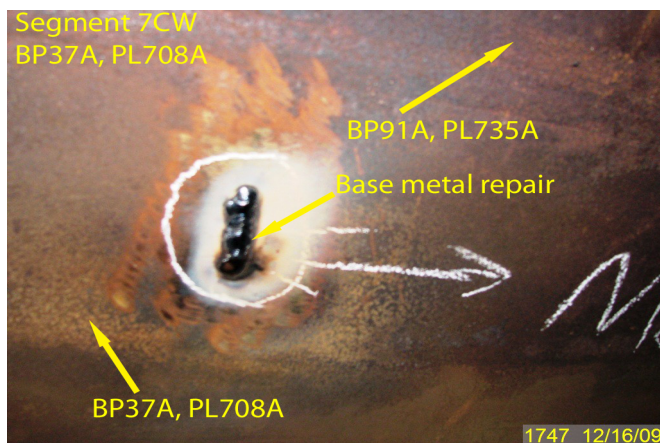
Segment 9BW

SMAW welding of weld joint SSD12A-PP76-232 located on Segment 9BW. Welder is identified as 037748 (4G). ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U5-FCM-1.

FCAW welding of weld joint SSD12A-PP76-256 located on Segment 9BW. Welder is identified as 045143 (2G). ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U5-F.

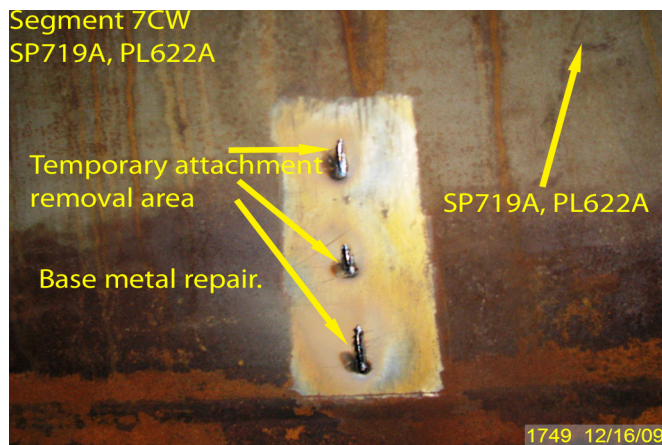
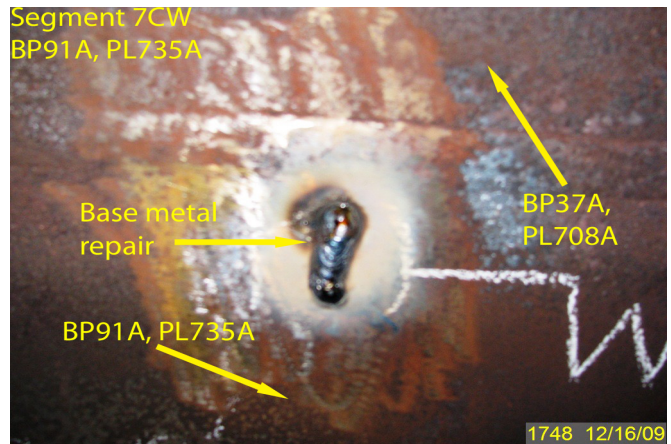
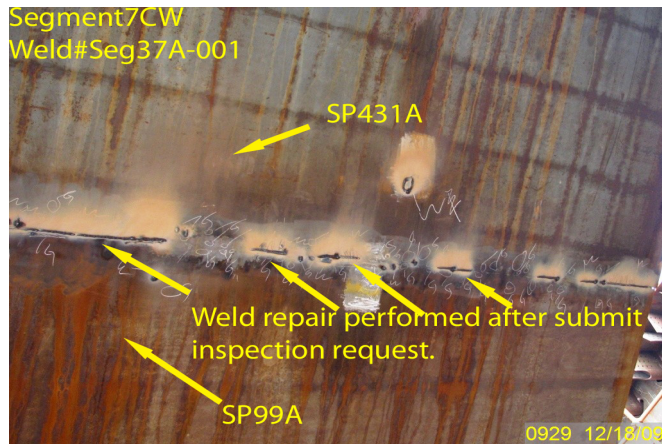
FCAW welding of weld joint SSD12A-PP76-257, 236 located on Segment 9BW. Welder is identified as 207465 (2G). ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U5-F.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
